

Date: Thursday, 24/07/2008 8:19:41 AM
User: Linda Lacelle

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 40739		
Estimate Number	: 10101		
P.O. Number	:	Part Number	: D2011101
This Issue	: 24/07/2008 S.O. No. :	Drawing Number	: D2011 REV. F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : PURCHASED PARTS	Drawing Revision	: F
Previous Run	: 40485	Material	:
Written By	:	Due Date	: 25/07/2008
Checked & Approved By	:	Qty:	1x Um: Each
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING
Issue P/O: 6827
Purchase Grote Mirror P/N: 28043
Possible supplier: UAP/NAPA
Material release note required

u 080724

(6)

2.0 28043 MIRROR 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
Mirror 6"

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

100% clip

split
18 08/08/06(x1)
18 08/07/25 (x3)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 08/08/06(x1)

5.0 D30141 Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1 Lock nut

100% clip

B25021

18 08/08/11

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Drawing Name: 6" MIRROR

Job Number: 40739

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960JD416L

Washer



Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

1108138

08/08/11

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch
9ml N/A Sikaflex-291/-241
Expiry date

1107893
10/2008

Start: 08/08/07 Time: 7h00

Finish: 08/08/08 Time: 7h00

08/08/11

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

08/10/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

08/10/10

1

10.0

QC21

FINAL INSPECTION/W/O RELEASE



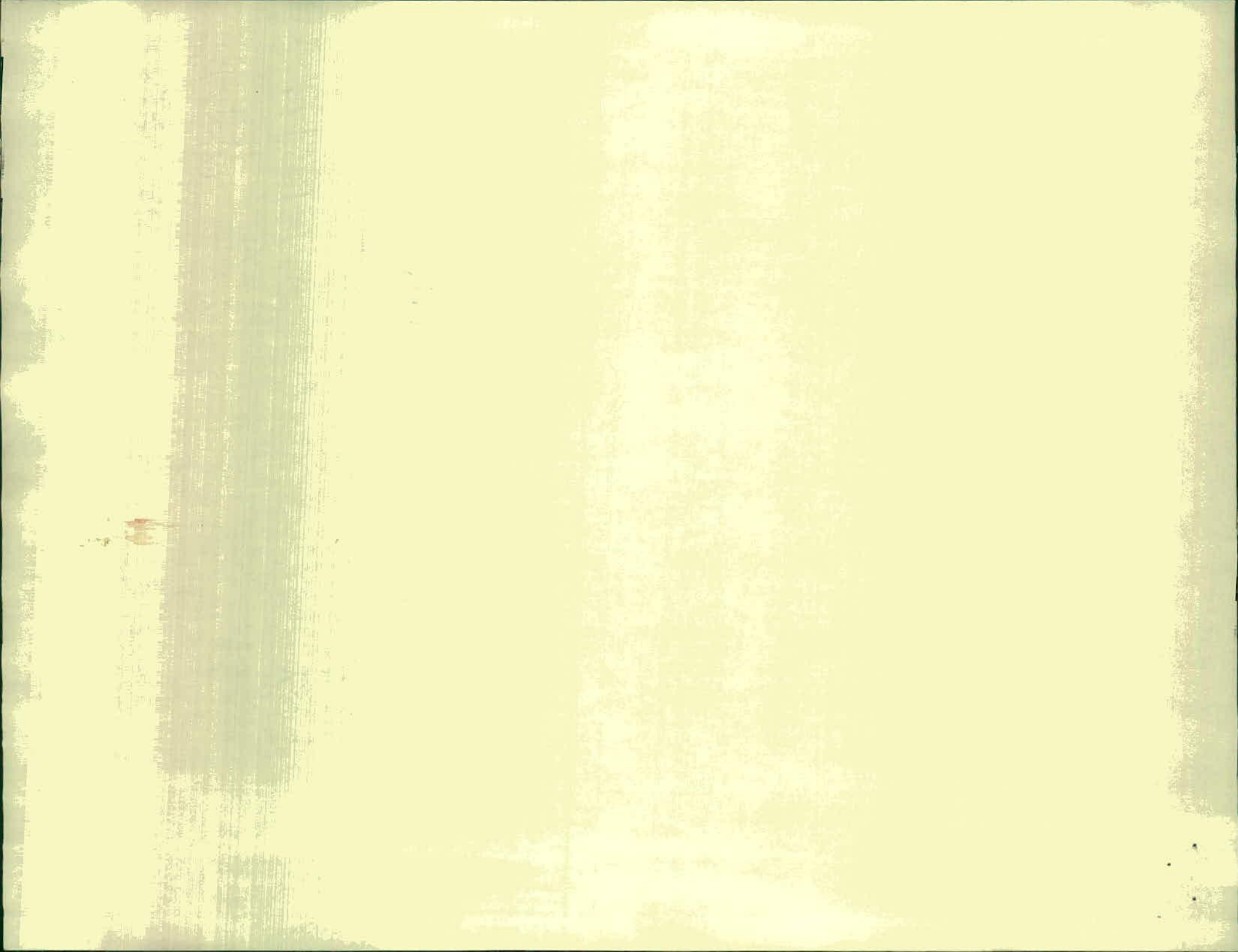
Comment: FINAL INSPECTION/W/O RELEASE

08/10/10

Job Completion

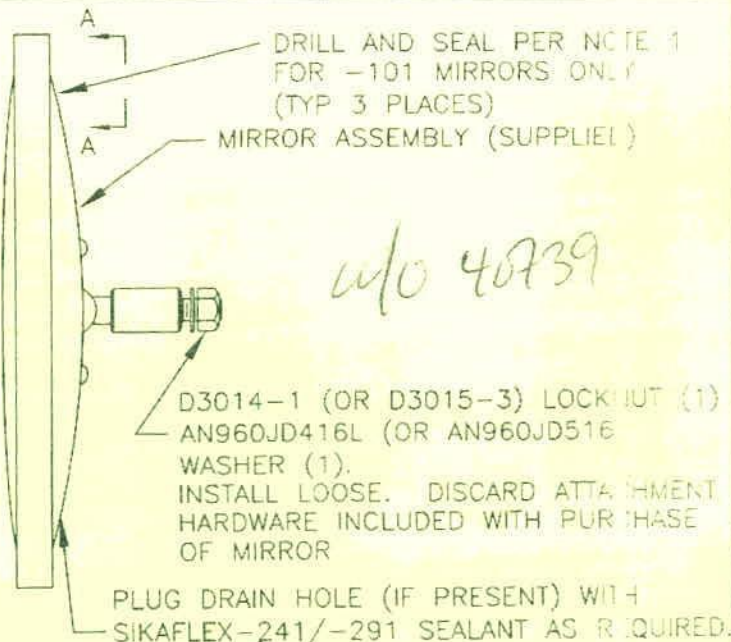
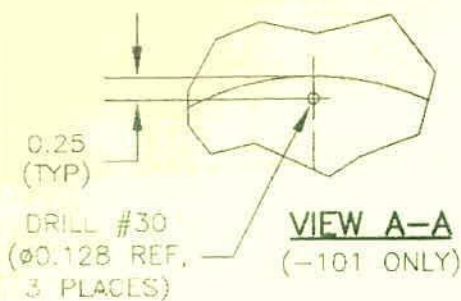


MF 08-10-10





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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**ACKLANDS
GRAINGER**

ACKLANDS - GRAINGER INC.
765 CAMERON ST.
HAWKESBURY ON K6A 2B7
(613) 632-2739

ENVOYER
A
REMIT
TO
EXPEDIER
SHIP
TO
A

ACKLANDS - GRAINGER INC.
PO BOX 2970

WINNIPEG MB R3C 4B5

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
K6A 1K7

PACKING SLIP ONLY
INVOICE TO FOLLOW

PACKING SLIP#
1417 0384707

1

PAGE
PAGE 10

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
K6A 1K7

NO. DE REFERENCE DU CLIENT CUST. REF. NO.		NO. DE LICENSE PROVINCIALE P.S.T. LIC. NO.		NO. DU CONTRAT CONTRACT NO.		EXP. DIRECTE DIR. SHIP		DATE DE LA COMMANDE ORDER DATE		DATE DE LA FACTURE INVOICE DATE	
26230		5827		6122 5207		N		07/24/2008		07/31/2008	
TIMES		NO. DE VERSEMENTS NO. OF PMTS		M.E.P. M.E.P.		DATE DU PREMIER VERSEMENT FIRST PAYMENT DATE		APP. DE CREDIT CREDIT AUTH.		S'APPLIQUE A: NO. DE FACTURE APPLY TO INVOICE NO.	
30 ***		0		0		00/00/0000 08:54					
NO. DE PIECE ITEM NO.		PRIX DE LISTE SUGG. LIST		QUANTITE COMMANDEE QUANTITY ORDERED		QUANTITE EXPEDIEE QUANTITY SHIPPED		CODE DE COMMANDE		PRIX PRICE	
DESCRIPTION										PAR PER ESC DIS	
043		27.96		1		1		EA		22.55	
CONVEX ASSY SS 6IN										1 22.55	
B.O. QTY: 1, STILL TO COME: 0											
BACKORDER FROM INVOICE# 0384611, DATED 07/28/2008											
SOUS TOTAL / SUB TOTAL 22.55											
STOMER PIC UP		DATE DE LIVRAISON REQUISE REQUESTED DELIVERY		COMPLAISANCE BILL OF LADING		LEVE DE COMMANDE B.O. CODE		9275		1.13	
								9305		1.80	
RECU PAR RECEIVED BY										25.48	
MONTANT TOTAL TOTAL AMOUNT											

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